



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2741**Job Sheet 204793****Part No:** D2741**Job Qty:** 40 pcs**Part Name:** Replacement Blade**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 12/19/19**Job Tracking No:****Due Date:** 2/10/20**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG REV E IPP Rev: D 00.11.15 Removed P/O turning - in house process EC IPP Rev: E 06-03-20 As Per
Rev C JLM IPP Rev: F

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	40 pcs		2/10/20	0.00	3.11	Bandsaw - 1		J.C. - 20-02-20
110	HAAS 4 Axis - B4B	40 pcs		2/10/20	1.00	27.45	HAAS - 1 - B4B		J.C. - 20-02-20
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	40 pcs		2/10/20	0.00	0.00	QC 8 - 12		J.C. - 20-02-25
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

**Container No:** S257996**Part:** D2741**Job No:** 204793**Serial No/Batch:** S257996**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 02/24/20

Plex 12/19/19 12:46 PM Dart.lajeunesse.marie

140	Small Fab - 2 - B4B	40 pcs	2/10/20	0.00	0.68	QC 8 - 76	
						QC 8 - 61	
						Small Fab - 1 - B4B	
						Small Fab - 2 - B4B	
						Small Fab - 3 - B4B	DAS 30 3-89
						Small Fab - 4 - B4B	FEB 27 2020
						Small Fab - 5 - B4B	
						Small Fab - 6 - B4B	
						Small Fab - 7 - B4B	
						Small Fab - 8 - B4B	
						Small Fab - 9 - B4B	
						Small Fab - Various 1 - B4B	
150	QC 5	40 pcs	2/10/20	0.00	0.00	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	DAS 40 9-89
						QC 5 - 9	DAS 82 9-89
						QC 5 - 50	
						QC 5 - 30	MAR 02 2020
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
160	Outsource - 1 - Heat Treat	40 pcs	2/10/20			ATL002 VO MEI 001	2020-03-03
170	Packaging 2-1 - Receive - B4B	40 pcs	2/10/20	0.00	0.00	Packaging 2 - 1 - B4B	
						Packaging 2 - 2 - B4B	
						Packaging 2 - 3 - B4B	
						Packaging 2 - 5 - B4B	APR 21 2020
						Packaging 2 - 4 - B4B	
						Packaging 2 - 6 - B4B	
						Packaging 2 - 7 - B4B	
						Packaging 2 - 8 - B4B	
						Packaging 2 - 9 - B4B	
						Packaging 2 - 10 - B4B	
						Packaging 2 - 11 - B4B	
						Packaging 2 - 12 - B4B	
						Packaging 2 - 13 - B4B	
						Packaging 2 - 14 - B4B	
						Packaging 2 - 15 - B4B	
						Packaging 2 - 16 - B4B	
						Packaging 2 - 17 - B4B	
						Packaging 2 - 18 - B4B	
						Packaging 2 - 19 - B4B	
						Packaging 2 - 20 - B4B	
						Packaging 2 - 21 - B4B	
						Packaging 2 - 22 - B4B	
						Packaging 2 - 23 - B4B	
						Packaging 2 - 24 - B4B	
						Packaging 2 - 25 - B4B	

					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
180	QC 6	40 pcs	2/10/20	0.00 0.00	QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	82
					QC 6 - 40	9-89
					QC 6 - 81	82
						APR 21 2020
190	Handfinish - 4-1-Assembly-B4B	40 pcs	2/10/20	0.00 2.47	Handfinish - 4 - 1 - B4B	20-4-25
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
200	Powdercoat - 2 White Gl(S)-B4B	40 pcs	2/10/20	0.00 1.02	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	20-05-5
					Powdercoat - 4 - B4B	
210	QC 3	40 pcs	2/10/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	DAS
					QC 3 - 68	59
					QC 3 - 9	
					QC 3 - 40	

220	Packaging 3-1 - Stock - B4B	40 pcs	2/10/20	0.00	0.00	QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
						Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	DAS
						Packaging 3 - 6 - B4B	28
						Packaging 3 - 7 - B4B	9-89
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
						Packaging 3 - 37 - B4B	
230	QC 21 - SA	40 pcs	2/10/20	0.00	0.00	QC 21 - SA - 21	DAS
						QC 21 - SA - 70	21
						QC 21 - SA - 53	9-89
						Broussard	

Part Op 100 - (Bandsaw) Cut blanks 13.850" long +0.063" -0.000"

Descriptions: 110 - HAAS CNC Vertical Machine)1-Machine per folio FA108 ***SEE NOTE 9 FOR HOLES***

130 - QC8- Inspect parts - second check)

140 - (Small Fab)1-Deburr 2-Bend per Dwg D2741

150 - (QC5- Inspect part completeness to step on W/O)

160 - Issue P/O: 46001 Harden material as per Dwg D2741 Min. Ultimate Tensile Strength = 152 ksi (34-40 HRC)
Min. Yield Tensile Strength = 141 ksi Test report or Certification required **Sand blast parts** *** ATTN : DO NOT ADD
OIL AFTER SANDBLAST ***

170 - (Receive & Inspect for Damage & Mat'l Certs)Ensure Test report or Certification attached

180 - QC6- All purchased or subcontracted products)

190 - (Assemble as per dwg)clean with wash & wipe to remove oil

200 - (White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel)START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

210 - (QC3- Inspect Part Finish)

220 - (Identify as per dwg & Stock Location: _____)

230 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4130NB0.500X03.000	4130 Bar 0.500 X 3.00	46.1640 ft (1.1541 ea)	100-Bandsaw - 1	5242149

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M4130NB0.500X03.000	46	47	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Blade	1.500Inches ± 0.010	1.510 1.490	1.500	
2	Blade	0.715Inches ± 0.010	0.725 0.705	.716	
3	Blade	0.516Inches + 0.008 - 0.001	0.524 0.515	.515	Diameter
4	Blade	2.000Inches ± 0.030	2.030 1.970	2.010	
5	Blade	13.750Inches ± 0.010	13.760 13.740	13.752	
6	Blade	1.060Inches + 0.012 - 0.001	1.072 1.059	1.059	Diameter
7	Blade	0.150Inches ± 0.010	0.160 0.140	.146	
8	Blade	2.930Inches ± 0.030	2.960 2.900	2.932	
9	Blade	0.375Inches ± 0.010	0.385 0.365	.376	
10	Blade	0.250Inches ± 0.030	0.280 0.220	.250	
11	Blade	0.250Inches ± 0.030	0.280 0.220	.250	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046001



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Attention: Bejenaru, Livia

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046001

PO Date: 3/3/20

Due Date: 3/24/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
2020-03-05

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	204793	D2741	D2741	Replacement Blade : Various STC's Issue P/O Metcore: Harden material as per Dwg D2741 Min. Ultimate Tensile Strength = 152 ksi (34-40 HRC) Min. Yield Tensile Strength = 141 ksi Test report or Certification required **Sand blast parts** *** ATTN : DO NOT ADD OIL AFTER SANDBLAST ***	Firmed X40 ✓	-	3/24/20	40 pcs	0 pcs	40 pcs	\$18.415/pcs	\$736.60
Grand Total:												\$736.60

KGuerin



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Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046001



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/5/20 9:13 AM Dart.Guerin.Kimberley

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL	EXPÉDITEUR	BON D'EXPÉDITION
Order	Shipper ID	Shipper
343453	1	145054

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À / Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT	BON DE LIVRAISON DU CLIENT	TYPE DE MATÉRIEL	DATE DE LA COMMANDE	TRANSPORTEUR
Customer PO	Customer Shipper No.	Material Type	Order Date	Carrier
HB046001		4130	2020/3/4	client

QUANTITÉ	No. PIÈCE	NOM DE LA PIÈCE	DESCRIPTION DE LA PIÈCE	POIDS
Quantity	Part No.	Part Name	Part Description	Weight

40 D2741 ✓
BLADE
(40) D2741 ✓
JOB 204793 ✓

140,

1 BOITE DE BOIS

TYPE DE CONTENEUR	# DE CONTENEURS	COMMENTAIRES CONTENEUR
Container Type	# Of Containers	Container Comments
BOITE DE BOIS	1	

CERTIFICAT

EXPÉDIÉ PAR: Shipped by:	
-----------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 40

POIDS EXPÉDIÉ / Weight Shipped : 140,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

APPROUVÉ
[Signature]

RECEIVED

APR 20 2020

DART AEROSPACE LTD.

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped:	40
POIDS EXPÉDIÉ / Weight Shipped :	140,00

Signature:

Date:

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
343453	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
HB046001	N/A	4130		

SPÉCIFICATIONS DU PROCÉDÉ processing specifications

SEL HARDEN

HARDEN AND TEMPER

SAE AMS 2759/1 REV.H

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	34 - 40 HRC	39 ✓ (907)	36 - 38 HRC ✓
TENSILE (KSI)	152 - 182 KSI	1 Metcor report# 7357; RL	168,6 - 168,6 KSI ✓
Yield Strength	141 KSI MIN	1 Metcor report# 7357; RL	158,1 - 158,1 KSI ✓

DAS
82
9-89

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
40	140	D2741 BLADE (40) D2741 JOB 204793 1 BOITE DE BOIS

17/4/20

COMMENTAIRES / comments

1 PIECE AU LAB POUR TENSILE

APPROUVÉ par / Approved by:



DATE: 2020-04-11

APPROUVÉ
ACQUÉ

Certificat de Conformance

Certificate of Compliance

BON DE TRAVAIL	343453
CHARGEMENT	1

560 BOUL. AIRTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

METCOR INC.

Tel. 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

CLIENT/customer: 215

DART AEROSPACE

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HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

COMMANDE DU CLIENT	CLASSIFICATION PIECE	MATÉRIEL	MAÎTRE D'OEUVRE	PROGRAM
customer po	part classification	material	prime	
HE016001	N/A	4130		

SPECIFICATIONS DU PROCÉDE

processing specifications

SEL HARDEN

HARDEN AND TEMPER

SAE AMS 2759/1 REVH

EXIGENCE / requirement / specified TESTS EXÉCUTÉS / performed / RESULTS DE TESTS / results

HARDNESS

34 - 40 HRC

39

38 - 38 HRC

TENSILE (KSI)

152 - 182 KSI

1

168.6 - 168.6 KSI

Metcor report# 7357; RL

Yield Strength

141 KSI MIN

1

158.1 - 158.1 KSI

Metcor report# 7357; RL

DESCRIPTION DES PIÉCES

POIDS weight

QUANTITE quantity

140

D2741

BLADE

(40) D2741

JOS 204793

1 BOITE DE BOIS

COMMENTAIRES / comments

1 PIÉCE AU LAB POUR TENSILE

APPROUVÉ par / Approved by:



DATE: 2020-04-11

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

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Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
343453	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
HB046001 ✓	N/A	4130		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
SEL HARDEN HARDEN AND TEMPER SAE AMS 2759/1 REV.H				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	34 - 40 HRC	39 (907)	36 - 38 HRC ✓	
TENSILE	152 - 182 KSI	1	168.6 - 168.6 KSI ✓	DAS 82 9-89
Yield	141 KSI MIN	1	158.1 - 158.1 KSI ✓	
Metcor report# 7357; RL				
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
40	140	D2741 BLADE ✓ (40) D2741 JOB 204793 1 BOITE DE BOIS		

COMMENTAIRES / comments

1 PIECE AU LAB POUR TENSILE

SALT HARDEN 1575°F - 45 MINS

SNAP TEMPER 400°F - 2:00 HRS

TEMPER 875°F - 5:00 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of AMS2759 & AMS2750.

All HT operations were in compliance with AMS2759 and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with AMS2759 and the purchase order and was found to meet the requirements.

This document and any attached documents may contain confidential or proprietary information and may be subject to export

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
343453	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

control laws and regulations. If you are not the intended recipient, you are notified that any dissemination, copying of this e-mail and any attachments thereto or use of their contents by any means whatsoever is strictly prohibited. Unauthorized export or re-export is prohibited.

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec AMS2759 et AMS 2750.

Le TT a été fait tel que requis par AMS2759 et toutes les vérifications et les tests demandés ont été faites et documentés.

Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec AMS2759 et le bon de commande et le matériel rencontre les exigences spécifiées.

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APPROUVÉ par / Approved by:

DATE: 2020-04-16

Lucie Desmarais
QA Technician



DAS
82
9-89



Metcor

Apr 9, 2020

AMS 2759 / 0.2% OFFSET YIELD / 1" GL.(4d)

Report No. 7357

Test Date 09-Apr-20 Testing Machine STM-100KN 0211506

Client DART AEROSPACE
Operator Rachid Lourichi
Material 4130

PO HB046001
W.O. 343453

Part # D2741

Strain Rate inch/inch/min 0.005

Load Cell S/N (TV110012), Units (LBS)

22480

Crosshead Speed (Inches / min) or Rate 0.5

Displacement Sensor

EZ.1-1 (5286)

Notes Ambient temperature : 23.5 ° C. Results are in compliance with customer and specification requirements.

Test No	Specimen ID	Diameter (in)	Yield (kpsi)	Tensile (kpsi)	Total Elong (%)	RA (%)
16185	343453-1	0.249	158.1	168.6	15.0	59.7
	Mean	0.249	158.1	168.6	15.0	59.7
	Std Dev					
	Specification (min)		141.0	152.0		
	(max)			182.0		

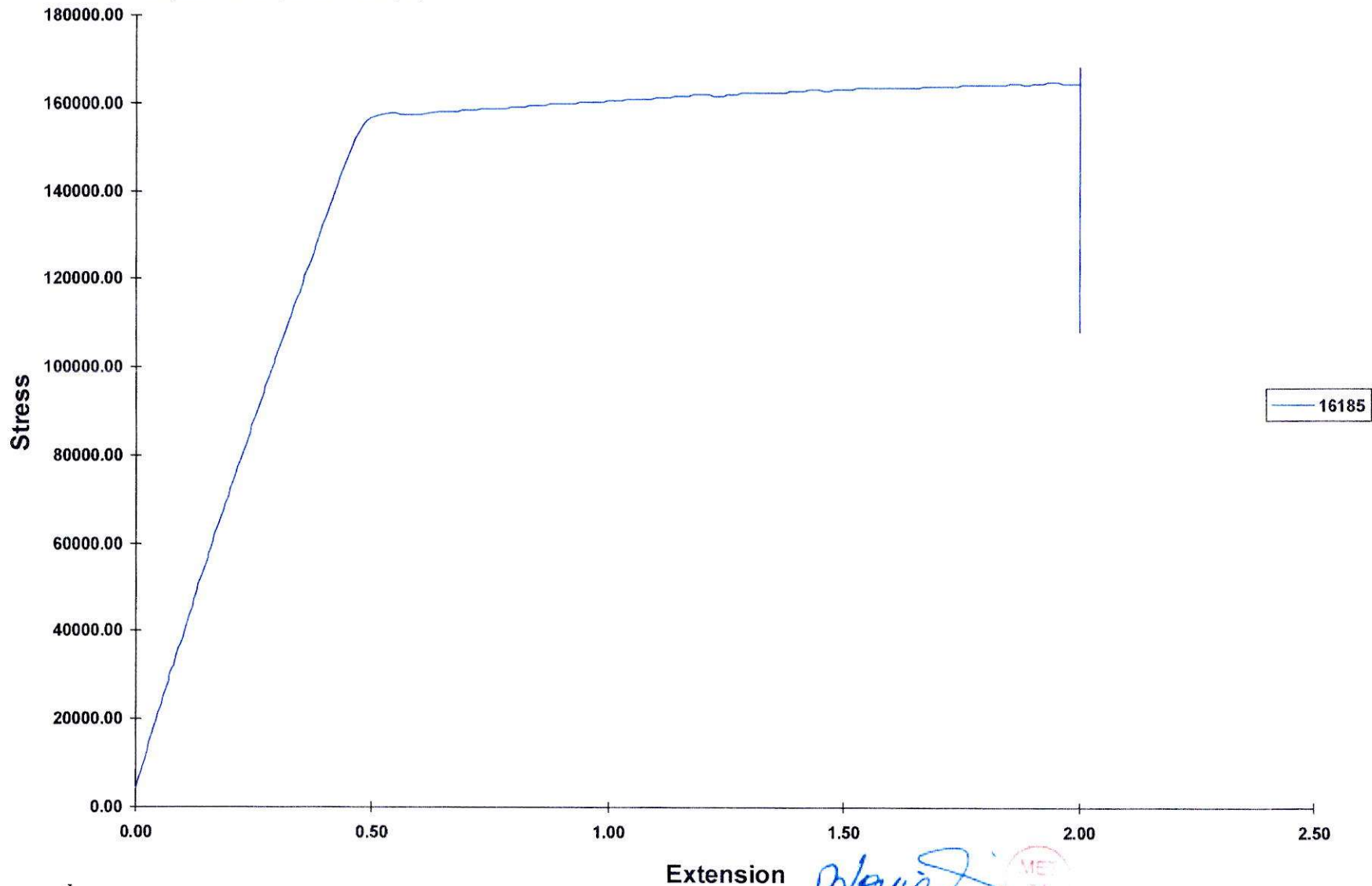
By:

Date: Apr 9, 2020

Test Performed in Accordance with AMS 2759, Rev. G

Report No 7357 **AMS 2759 / 0.2% OFFSET YIELD / 1" GL.(4d)**

Stress (Lbs / Inches ²) vs Extension (%)



Extension

By :  